

Date: Thursday, 06/11/2008 3:45:47 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FUEL PURGE CANISTER
<b>Job Number</b> :	43256		
<b>Estimate Number</b> :	10442		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32623
<b>This Issue</b> :	06/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3262 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41823B	<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 08.11.08</u>	<b>Due Date</b> :	14/11/2008
<b>Comment</b> :	Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
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**Comment:** Qty.: 0.9668 f(s)/Unit Total: 9.6684 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B0.500x06.000)  
 Identify for D3262-3  
 Batch: M105145

20 08/11/07

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: 6.000" x 0.500" x 5.400" long Bar  
 Machine as per Folio FA457 and Dwg D3262  
 Identify for D3262-3  
 Deburr

ML 08/11/09

⑩

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per dwg D3262

B.A. 08/11/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B.A. 08/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/11/2008 3:45:47 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 43256

Part Number: D32623

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 08/11/10*

(10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 163

*SS 08/11/10*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/11/12*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*11/08/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43256
<b>Description:</b> Cap		<b>Part Number:</b> D3262-3
<b>Inspection Dwg:</b> D3262	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.070 x 45°	✓			
0.45	+/-0.030	0.448	✓			
R0.063	+/-0.010	R0.063	✓			
0.080	+/-0.010	0.080	✓			
0.33	+/-0.030	0.333	✓			
Ø5.005	+0.010/-0.000	Ø5.005	✓			
0.688	+0.015/-0.000	0.689	✓			
3.25	+/-0.005	3.2485	✓			
0.875	+/-0.010	0.875	✓			
Ø0.516	+0.005/-0.000	Ø0.521	✓			
Ø5.165	+/-0.010	Ø5.165	✓			
0.083	+0.015/-0.000	0.093	✓			
Ø0.580	+0.005/-0.000	Ø0.581	✓			

<b>Measured by:</b> M.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/11/09	<b>Date:</b> 08/11/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

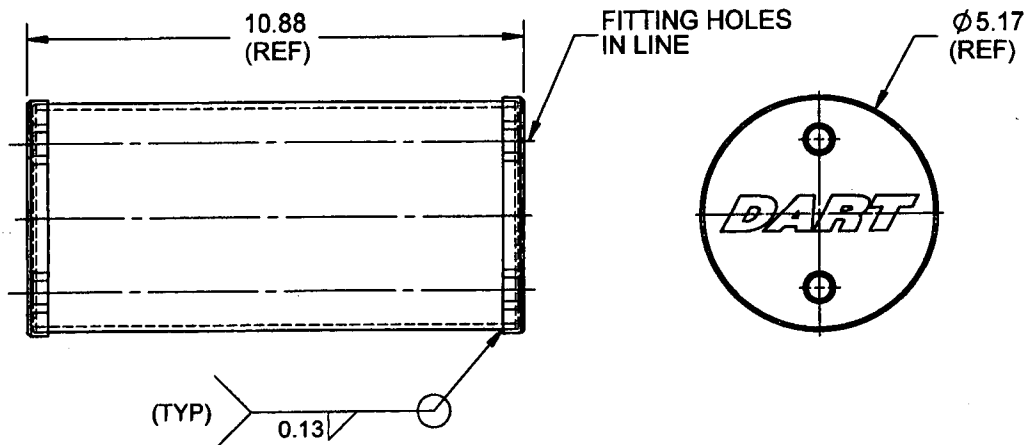
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 1 OF 2
DATE <b>06.08.31</b>		TITLE <b>FUEL PURGE CANISTER</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

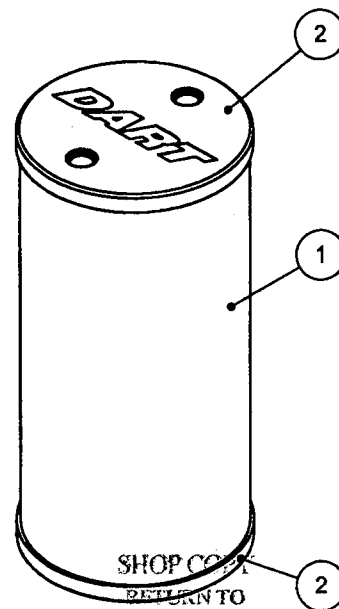
RELEASED

06.09.19 *H***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



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WITHOUT NOTICE  
WORK ORDER

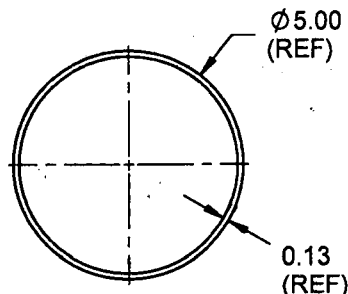
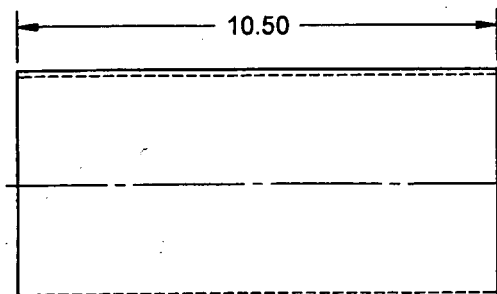
43256

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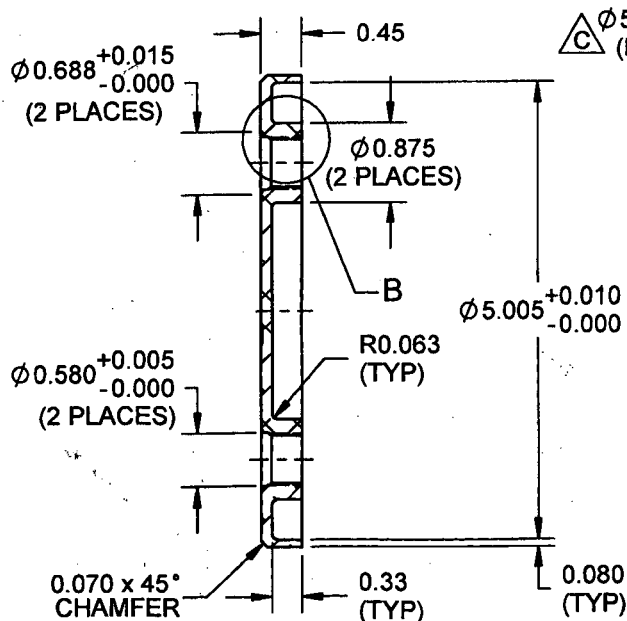
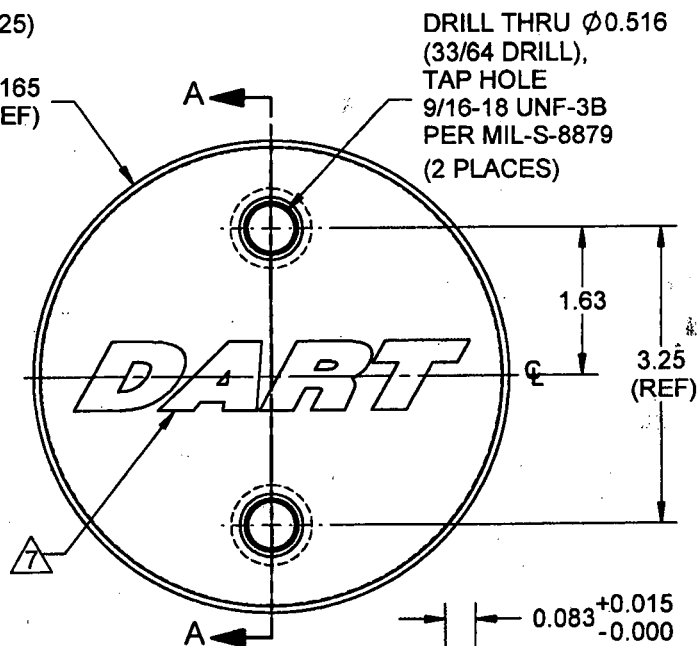
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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 2 OF 2
DATE <b>06.08.31</b>	TITLE <b>FUEL PURGE CANISTER</b>		SCALE 1:4

**RELEASED**  
06.09.19**D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR  
QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**  
SCALE 1:2

DRILL THRU  $\phi 0.516$   
(33/64 DRILL),  
TAP HOLE  
9/16-18 UNF-3B  
PER MIL-S-8879  
(2 PLACES)

**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

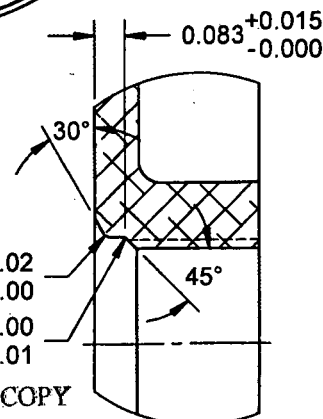
**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP LETTERS  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

R0.02 +0.02/-0.00  
SHOP COPY  
R0.02 +0.00/-0.01  
REWORK  
ENGINEERING

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WORK ORDER  
NO. 43254

**DETAIL B**  
SCALE 2:1

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